

Date: Tuesday, 24/06/2008 9:09:23 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HELI UTILITY BASKET LH/RH
Job Number : 40003	
Estimate Number : 10197	
P.O. Number :	Part Number : D350607041
This Issue : 24/06/2008 S.O. No. :	Drawing Number : D350-607 REV F P7-9
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : LARGE FAB ASSY	Drawing Revision : F
Previous Run : 40002	Material :
Written By :	Due Date : 11/07/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JLD 08.6.24</u>	
Comment : Est Rev:M 05.09.02 Added D2856-400-720 KJ/JLM Est Rev:N 07-12-21 ECN1068 DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL JLD 08.6.26
 Photocopy bluefile & type labels per PPPD350-607-041 CHG006

S 08/7/16

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick: Assembly Kit

3.0	40003A	BASKET BASE ASSEMBLY (350)
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Comment: Sub-Component BASKET BASE ASSEMBLY (350)
 1 x D2221 Batch 40003A

CP 08/07/16 @

4.0	40003B	350/212/130 BASKET LID
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Comment: Sub-Component 350/212/130 BASKET LID
 1 x D2512 Batch 540003B

CP 08/07/16 @

5.0	D2022101	Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Pick: Assembly Kit
 Qty Part Number Description Batch
 2 D2022-101 Spacer 37521

AS 08/07/07 @

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 24/06/2008 9:09:23 AM
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Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 40003

Part Number: D350607041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D2258200	Placard 200lb
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2258-200 Label 39439

JS 08/07/07 (X)

7.0	D2332041	Lid Prop Assembly 6.69" long
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2332-041 Prop Ass'y 38797

JS 08/07/07 (X)

8.0	D2530	Handle Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2530 Handle Weldment 37563

Sylvie changed
Batch #

B40211*

this one
is new

JS 08/07/07 (X)

9.0	D2535	Spring
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2535 Spring 37071

JS 08/07/07 (X)

10.0	D2537	Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2537 Bushing 39513

JS 08/07/07 (X)

11.0	D27283	Dart Logo Label - large
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2728-3 Label 22553

JS 08/07/07 (X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number:



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12.0	D2931	Bumper
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2931 Bumper 21139

JS 08/07/07 (X)

13.0	AN316A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN3-16A Bolt M66815

JS 08/07/07 (X)

14.0	AN47A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN4-7A Bolt M107321

JS 08/07/07 (X)

15.0	AN422A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 AN4-22A Bolt M104937

JS 08/07/07 (X)

16.0	AN424A	Bolt
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 AN4-24A Bolt M104547

JS 08/07/07 (X)

17.0	AN517A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN5-17A Bolt M106815

JS 08/07/07 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Part Number: D350607041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN960JD8

Washer

M107650

JS 08/07/07 (X)

19.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN960JD416

Washer

M07939

JS 08/07/07 (X)

20.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN960JD416L

Washer

108138

JS 08/07/07 (X)

21.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN960JD516

Washer

M107959

JS 08/07/07 (X)

22.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN970-4

Washer

M108077

JS 08/07/07 (X)

23.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 MS20600AD4W3

Rivet

18071

JS 08/07/07 (X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 40003

Part Number: D350607041

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) 107665

KS 08/07/07 @

25.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L4 Nut (or -4) M107478

KS 08/07/07 @

26.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L5 Nut (or -5) M105077 M107939

KS 08/07/07 @

27.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D350-607

Seal support gusset seam with white sikaflex-291 Batch: M107804

Expiry date: 10/2008

EF 08/07/16 @

28.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/16 @

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 40003

Part Number: D350607041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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30.0	D22301	Lug
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2230-1

Lug

39315

JS 08/07/07 (X)

31.0	D22303	Lug
------	--------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2230-3

Clamp

39404

JS 08/07/07 (X)

32.0	D23241	Strut Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 *D2324-1

Strut Ass'y

36749

JS 08/07/07 (X)

33.0	D2732	Rubber Extrusion
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Comment: Qty.: 2.0000 f(s)/Unit Total : 2.0000 f(s)

Rubber Extrusion

8x D2732-030 (cut to 3")

Batch:

37632

JS 08/07/07 (X)

34.0	AN412A	Bolt
------	--------	------



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

5 AN4-12A

Bolt

M105143

JS 08/07/07 (X)

35.0	AN415A	Bolt
------	--------	------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN4-15A

Bolt

M107737

JS 08/07/07 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

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Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 40003

Part Number: D350607041

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

AN960JD416

Washer



Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

26 AN960JD416

Washer

M107939

SS 08/07/07 (X)

37.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

13 MS21042L4

Nut (or -4)

M107478

SS 08/07/07 (X)

38.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 08/07/16 (X)

39.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-607-041

Location: H

SS 08/07/16

(X)

40.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SS 08/07/18

Job Completion



MF 08-07-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-607-041/-043 (LH installation)	88 lb 39.9 kg	- 48 in - 1.22 m	- 4224 in-lb - 48.7 m-kg	135 in 3.43 m	-11880 in-lb -136.9 m-kg
D350-607-041/-043 (RH installation)	88 lb 39.9 kg	+ 48 in + 1.22 m	+ 4224 in-lb + 48.7 m-kg	135 in 3.43 m	11880 in-lb 136.9 m-kg

5. PARTS LIST

Qty -041	Qty -043	Part Number	Description
X		D350-607-041	HELI-UTILITY-BASKET
	X	D350-607-043	HELI-UTILITY-BASKET
2	5	D2022-101	SPACER
1	1	D2221	BASKET BASE ASSEMBLY
4	4	D2230-1	LUG
4	4	D2230-3	CLAMP
1	1	D2258-200	LABEL
1	1	D2324	STRUT
1	1	D2332-041	PROP ASSEMBLY
1		D2512	BASKET LID ASSEMBLY
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
2	2	D2537	BUSHING
4	4	D2856-400-720	ABRASION STRIP
2	2	D2931	BUMPER
	1	D2989-041	BASKET LID ASSEMBLY (OUTSIDE)
	1	D2989-043	BASKET LID ASSEMBLY (INSIDE)
2	2	AN3-16A	BOLT
2		AN4-7A	BOLT
5	5	AN4-12A	BOLT
8	10	AN4-13A	BOLT
1	7	AN4-22A	BOLT
1		AN4-24A	BOLT
4	4	AN5-17A	BOLT
2	2	MS20600AD4W3	RIVET (OR CR9163-4-3)
28	40	AN960JD416	WASHER
2	2	AN960JD416L	WASHER
4	4	AN960JD516	WASHER
2	2	AN960JD8	WASHER
4	4	AN970-4	WASHER
2	2	MS21042L3	NUT (OR MS21042-3)
17	22	MS21042L4	NUT (OR MS21042-4)
4	4	MS21042L5	NUT (OR MS21042-5)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40003

Date: Tuesday, 24/06/2008 9:09:33 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BASKET BASE ASSEMBLY (350)
Job Number :	40003A		
Estimate Number :	10189		
P.O. Number :		Part Number :	D2221 <i>AD 01-05-24</i>
This Issue :	24/06/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2221 <i>✓</i> , D2235
First Issue :	//	Project Number :	N/A
Previous Run :	40002A	Drawing Revision :	F/B1
Written By :		Material :	
Checked & Approved By :	<i>JUL 08.6.24</i>	Due Date :	11/07/2008
Comment :	Est Rev:J 05.09.02 Added D3442-1KJ/JLM		

Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31661	Basket Hoop
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4	D3166-1	RIB	<i>B39443 (3) B39673(1)</i>
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SAD 08/06/26

①

2.0	D22323	Basket Hinge
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2	D2232-3	Hinge bracket	<i>B39334</i>
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SA 08/07/09

3.0	D2325	Support Gusset (350 Basket)
-----	-------	-----------------------------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4	D2325	Support Gusset	<i>B39913</i>
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SA 08/07/09

4.0	D23273	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2	D2327-3	Bushing	<i>B37541</i>
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SA 08/07/09

① →

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2221 PAR #: N/A Fault Category: Prod/Prod Mgr NCR: Yes No DQA: D Date: 08/07/09
 QA: N/C Closed: D Date: 28/07/09

NCR: <u>40003 A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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08/07/09	#4.0	After welding welder noticed that he welded the wrong D2327-3 in the wrong D2221-3. Re-welder thought he was welding B35741 but took the parts from the LID employee was not paying attention	<u>BS/ML</u>	Scrap and Destroy and Replace D2221-3 B2 <u>M108250</u> <u>B35741</u> <u>(43)</u> D2327-3 B2 <u>B35741</u> <u>(43)</u>	<u>BS</u> 08/07/09	<u>S</u> 08/07/09	<u>BS/ML</u>	<u>S</u> 08/07/09

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Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 40003A

Part Number: D2221

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2581 Mounting Bracket B39046

SH 08/07/09

6.0 D34421 Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3442-1 Shim B040392 ✓

Pl 08.07.14

7.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 41.6745 sf(s)/Unit Total: 41.6745 sf(s)

Pick:

Qty Part Number Description Batch

39.69 sf M304EX0.75-16F Expanded Metal M108152

SAD 08/06/26 ①

8.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 29.4000 f(s)/Unit Total: 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing

Batch: M108153

SAD 08/06/26 ②

9.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

SAD 08/06/26 ①

SH 08/07/15

4-Remove all markings on material before welding

SA

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

Pl 08.07.15

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 40003A

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

D 08-07-15 (1)

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 08/07/15 (+)

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

START TIME:

11:00am

OVEN TEMPERATURE:

400°F

FINISH TIME:

11:30pm

2ND COAT:

START TIME:

11:45am

OVEN TEMPERATURE:

400°F

FINISH TIME:

12:15pm

08-07-15

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M 08/07/15

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/18

Job Completion



MF 08-07-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

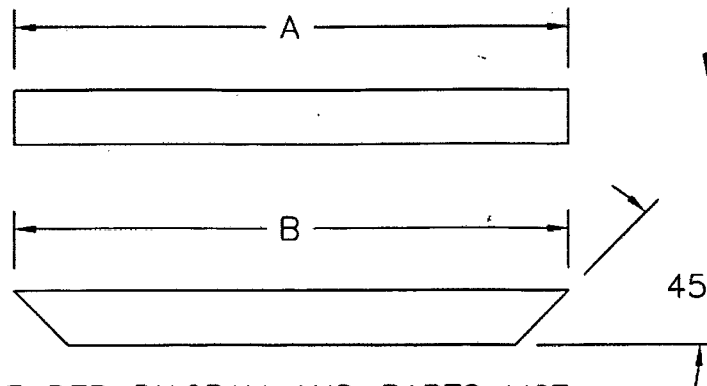
NOTE: Date & initial all entries

DART

DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2221	REV. F SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE NTS
C	95.11.21	SEPARATE BASKET AND LID	
D	96.06.21	CHANGE LATCH	
E	01.04.19	CHANGE HINGE	
F	05.06.07	ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS	

RELEASED05.08.19 *[Signature]***PARTS LIST FOR D2221 BASKET BASE ASSEMBLY**

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	—	96.00	RIB
D2221-3	2	—	25.50	RIB
D2221-5	2	18.88	—	RIB
D2221-7	1	55.25	—	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-1	2	N/A	N/A	SHIM



PH 05.06.24
UNDER REVIEW
08.02.05 PH
TUBING TO BE
CHANGED TO 0.065
WALL
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40003H

D2221-1/-3/-5/-7

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
(REF. DART SPEC M304TS0.750W.060) *0.065 PH 06.06.29*
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) DRILL $\phi 0.257$ HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH D2989-041/-043 BASKET LID

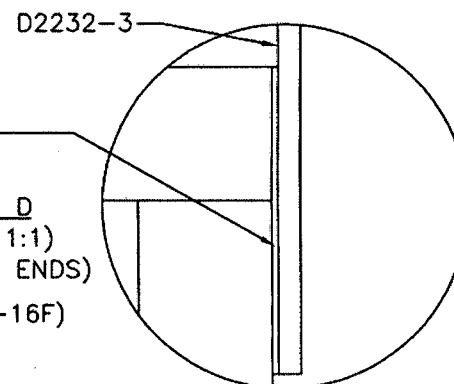
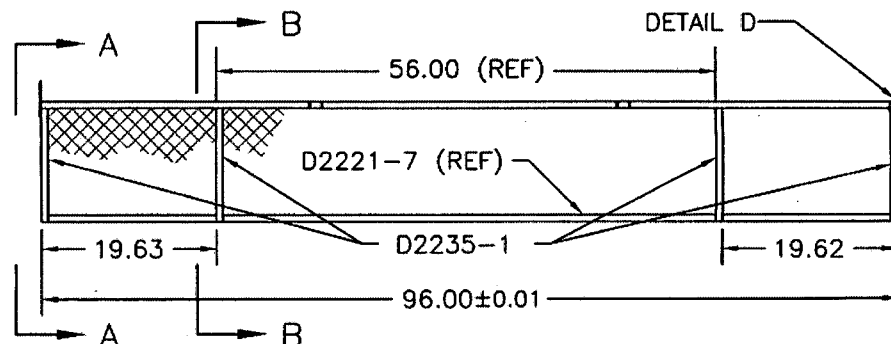
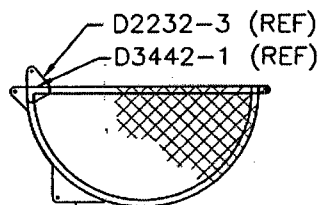
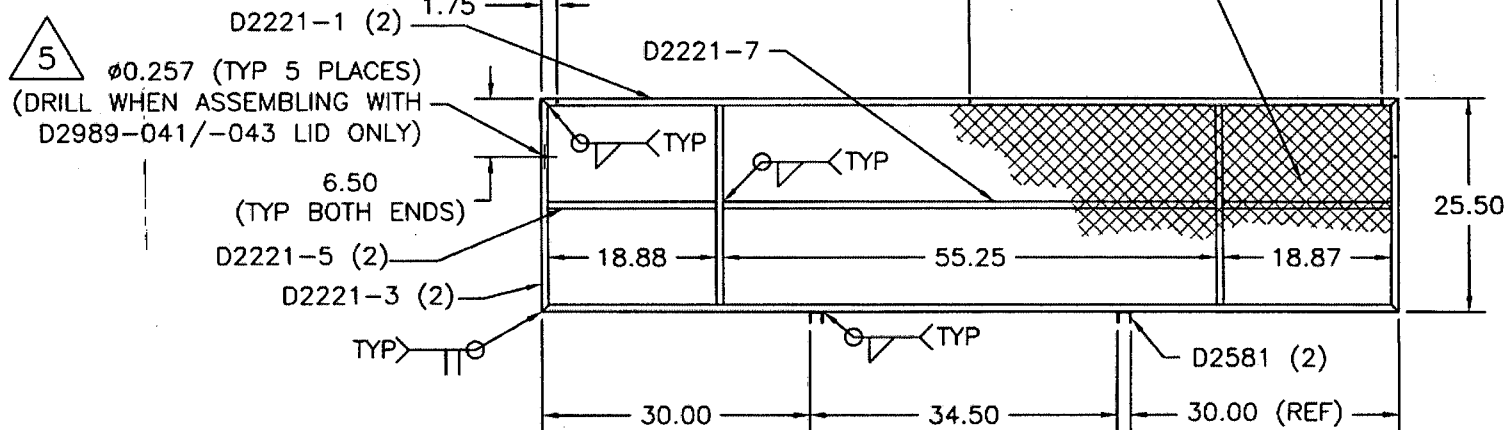
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2221	SHEET 2 OF 3
DATE	05.06.07	TITLE	BASKET BASE ASSEMBLY (350)	SCALE	1:20

SKIN INSIDE SURFACE OF
BASKET WITH MESH. TACK
WELD EACH END OF STRAND
TO FRAME



UNDER REVIEW
08.02.05
TUBING TO BE
CHANGED TO 0.065
WALL
01.06.24

RELEASED
05.08.19

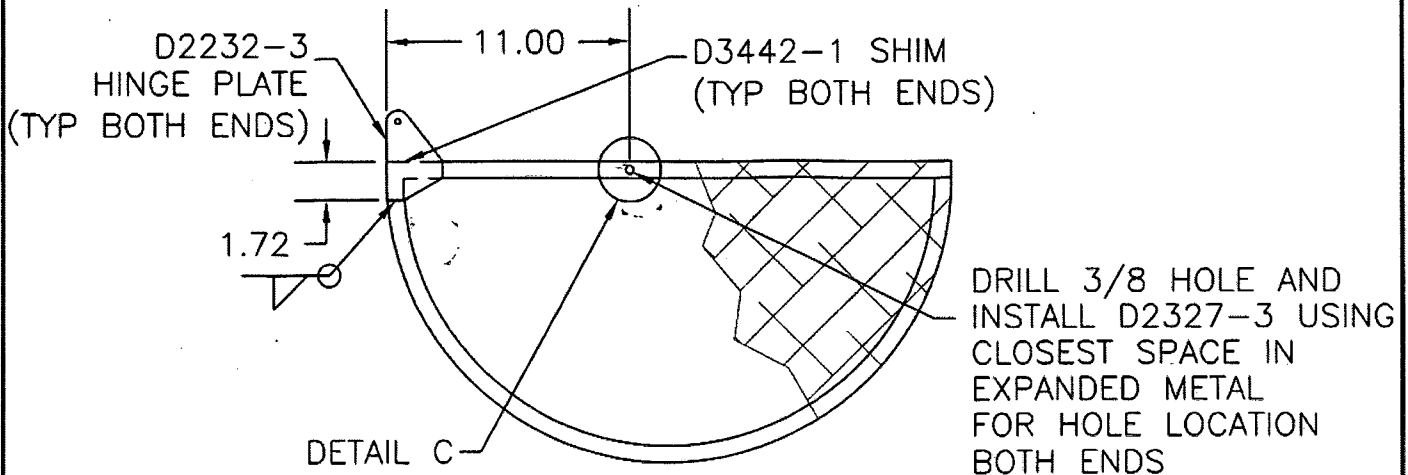
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WITHOUT NOTICE
WORK ORDER
100034

D2221 BASKET BASE ASSEMBLY

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

DART

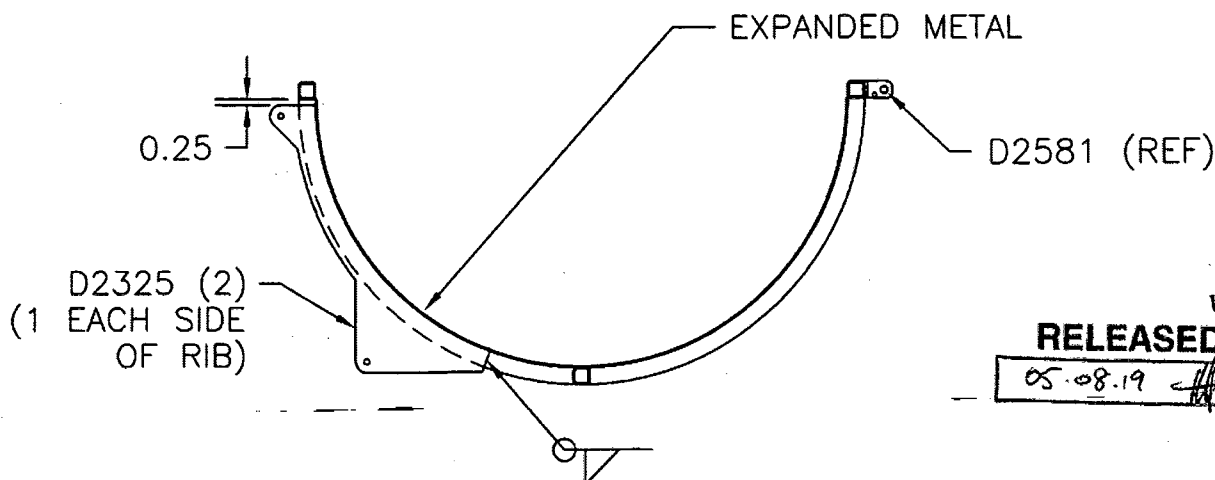
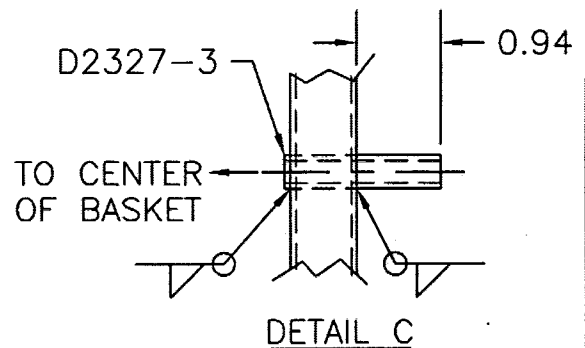
DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2221	REV. F SHEET 3 OF 3
DATE 05.06.07	TITLE BASKET BASE ASSEMBLY (350)		SCALE 1:8



SECTION A-A SAME BOTH END RIBS

UNDER REVIEW
08.02.06 PH

TUBING TO BE
CHANGED TO 0.065
WALL PH 03.06.24



SECTION B-B SAME BOTH CENTER RIBS

RELEASED

05.08.19 [Signature]

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WITHOUT NOTICE
WORK ORDER
NO. 400037

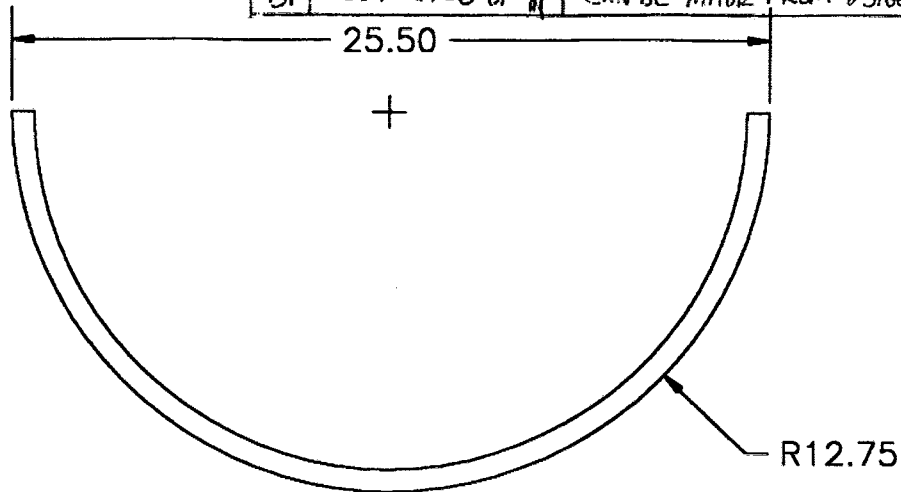
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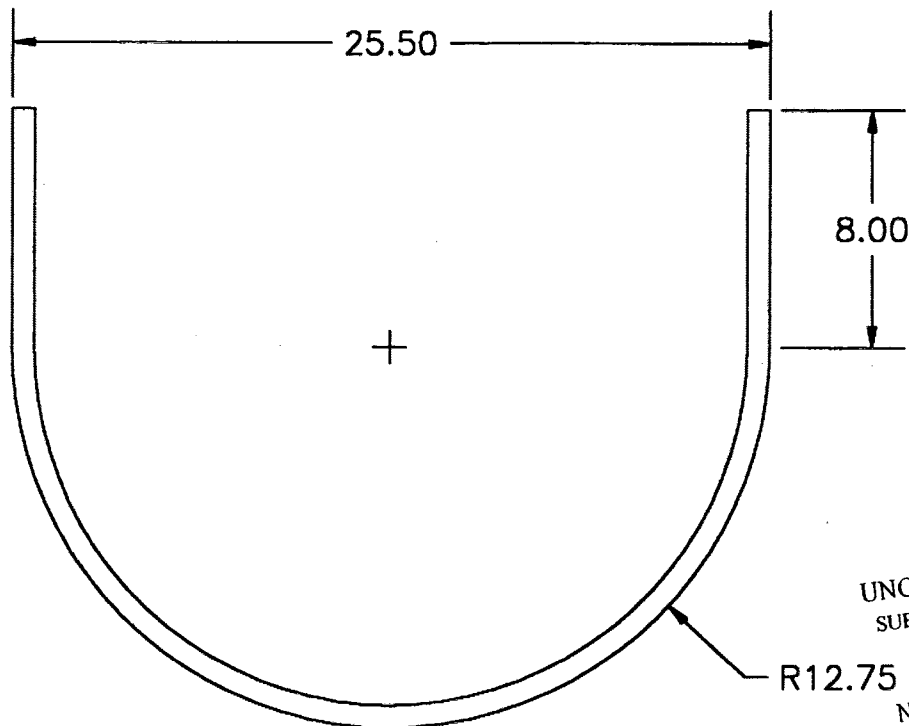
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED <i>BW</i>	APPROVED <i>BW</i>	D2235	SHEET 1 OF 1
DATE	TITLE		SCALE
94:12:16	BASKET RIBS		
BI	02.08.06 <i>U/H</i>	CAN BE MADE FROM D3166-1	


RELEASED
R 960507



D2235-1



D2235-3

CAN BE MADE FROM D3166-1 
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 400030

Date: Tuesday, 24/06/2008 9:09:42 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350/212/130 BASKET LID
 Job Number : 40003B
 Estimate Number : 10193
 P.O. Number :
 This Issue : 24/06/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D2512
 First Issue : // Type : LARGE FAB ASSY Drawing Number : D2512 UNDER REVIEW *pt 03.06.24*
 Previous Run : 40002B Project Number : N/A
 Material :
 Due Date : 11/07/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : *JUD 08.06.24*
 Comment : Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/
 RF
 Est Rev:N 06.04.05 Added level21 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)

Pick: *0.065 pt 03.06.24*

3/4"x3/4" 304/316 SS tube .063" wall

Batch: *21108153*

SAD 08/06/26 *(D)*

2.0 D31663 Basket Hoop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3166-3 Basket Hoop

038780

SAD 08/06/26

3.0 D2506 Label Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2506 Label Plate

337446

Cpl 08.07.15

4.0 D23271 Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2327-1 Bushing

340084

Cpl 08.07.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 24/06/2008 9:09:42 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 40003B

Part Number: D2512

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0

D22321

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description
2	D2232-1	Hinge plate

Batch

B35684 → 1 ✓
B39454 → 1 ✓

PL 08.07.15

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description
2	D2581	Mounting Bracket

Batch

B39046 ✓

PL 08.07.15

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty	Part Number	Description
18 sf	M304EX0.75-16F	Expanded Metal

Batch

M108152

SAD 08/06/26 ①

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

SAD 08/06/26 ①
PL 08.07.15

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08.07.15 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 24/06/2008 9:09:42 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 40003B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 08/07/15 (X)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1st

2nd

START TIME:

11:00am

11:45am

OVEN TEMPERATURE:

400°C

400°F

FINISH TIME:

11:30pm

12:15pm

08-07-15 (X)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch:

M108996 ML

08/07/15 (X)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-07-15 (X)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

GA

08/07/16 (X)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/16 (X)

Job Completion



MF 08-07-17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

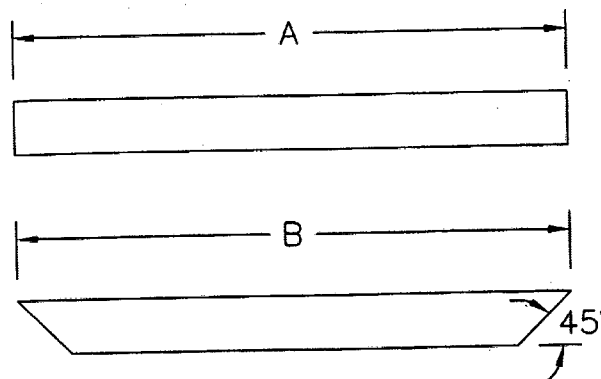
NOTE: Date & initial all entries

DART

DESIGN BW	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2512	REV. D SHEET 1 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	
A		95.11.21	NEW ISSUE
B		96.05.24	ADDED LATCH CHANNEL & LABEL PLATE
C		99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074
D		01.04.19	CHANGE HINGE
D1		# UP 03.01.20	ADD D2012-117 FOR D130-701-041
D2		# UP 04.09.20	TACK WELD ONE-SKID AREA

RELEASED
01.04.27 #**PARTS LIST FOR D2512 BASKET LID ASSEMBLY**

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



PH 01.06.24
UNDER REVIEW
08.02.05 PH
TUBING TO BE
CHANGED TO 0.065
WALL
SHOP COPY
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ENGINEERING
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WITHOUT NOTICE
WORK ORDER
NO. 40003B

D2512-1/-3/-5/-7

CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST, 0.065 PH 01.06.24
MATERIAL: AISI 304/316 SS, 3/4 X 3/4-X 0.060 WALL SQUARE TUBING
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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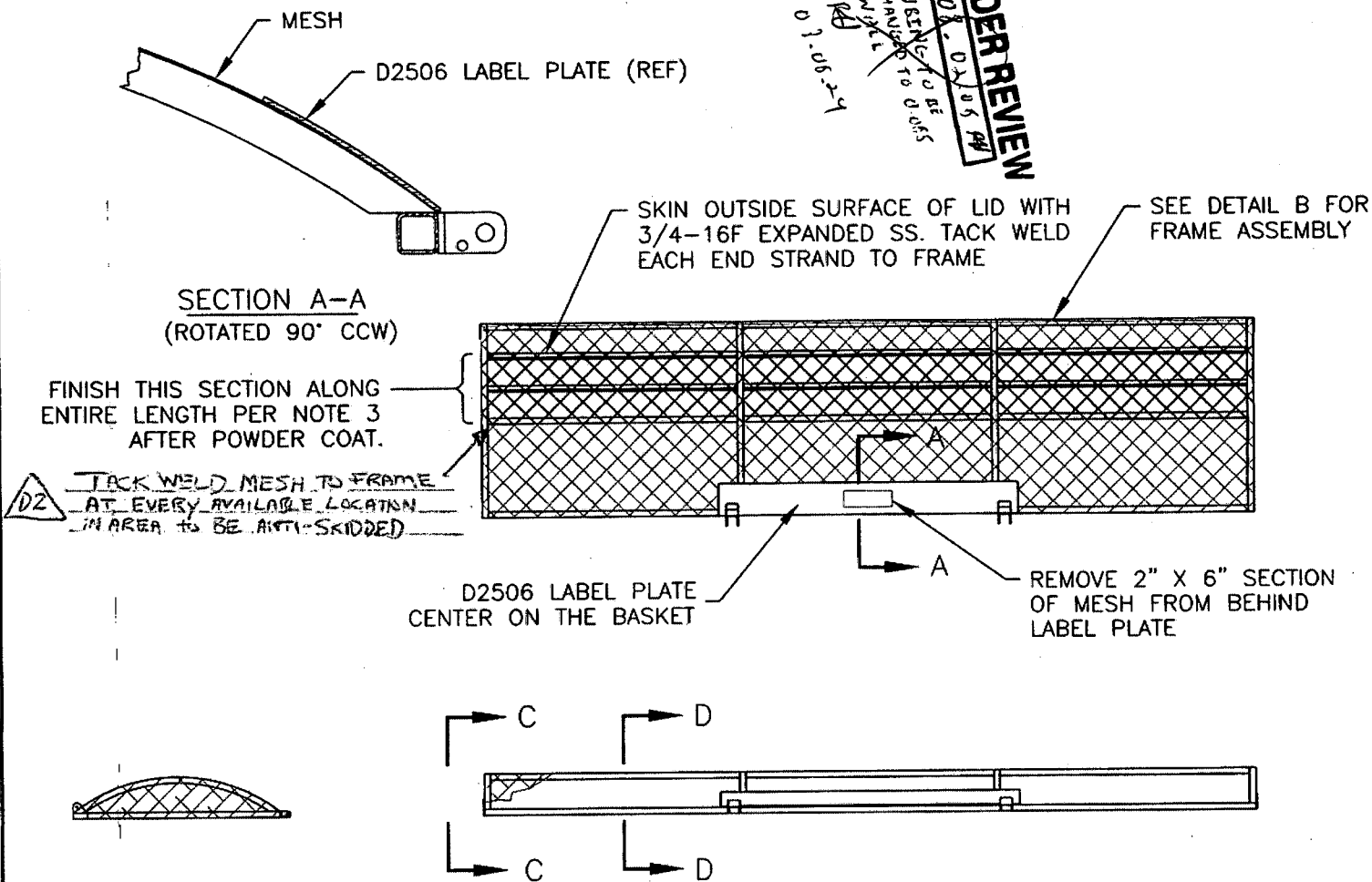
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				HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2512
DATE	01.04.19	TITLE	BASKET LID ASSEMBLY (350/212)	REV. D
				SHEET 2 OF 4
				SCALE 1:20

UNDER REVIEW
01.04.19
TUBING TO BE
CHANGED TO 0.065
WALL
01.06.19



D2512 BASKET LID ASSEMBLY

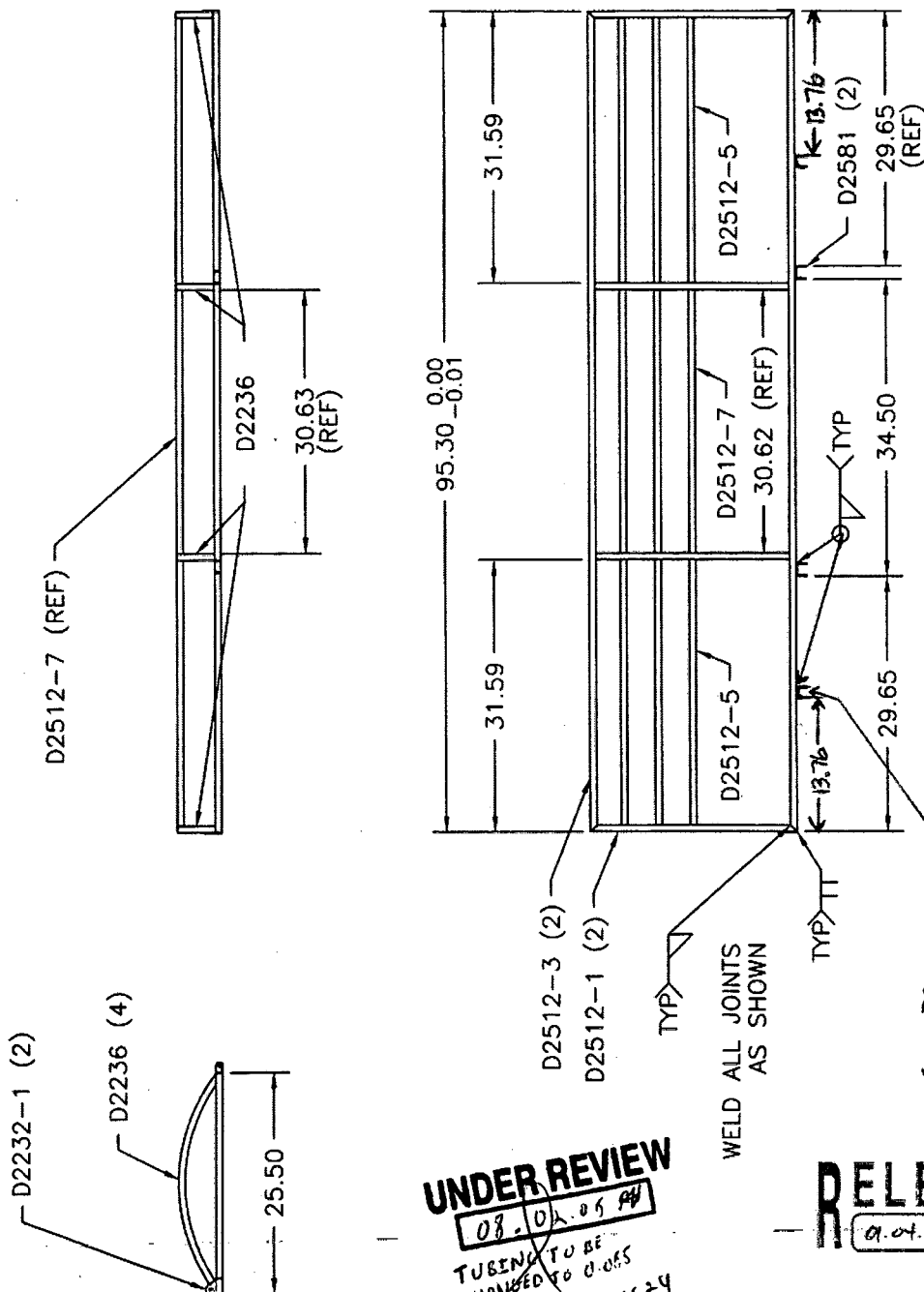
MESH MATERIAL: 3/4-16F EXPANDED SS
 FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
 SPRAY PAINT BLACK INSIDE SURFACE
 SPRAY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 DIMENSIONS ARE IN INCHES

NO. 100035
 WORK ORDER
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01.04.27

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CHECKED #	APPROVED #	DRAWING NO. D2512	REV. D SHEET 3 OF 4
DATE 01.04.19	TITLE BASKET LID ASSEMBLY (350/212)		SCALE 1:20



DETAIL B
FRAMEWORK SHOWN FOR CLARITY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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NO. 400033

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WALL PH 01.06.24

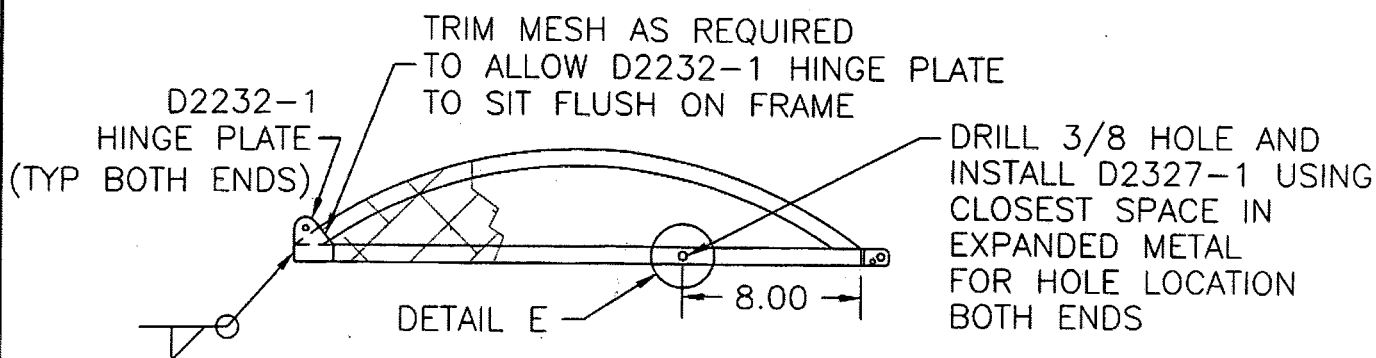
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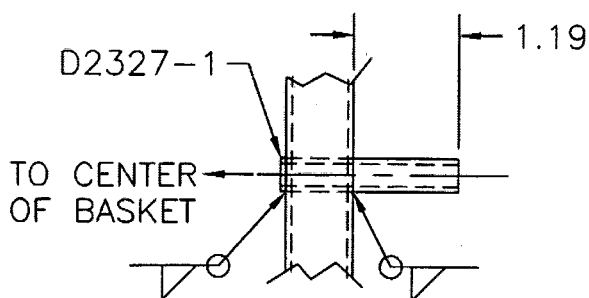
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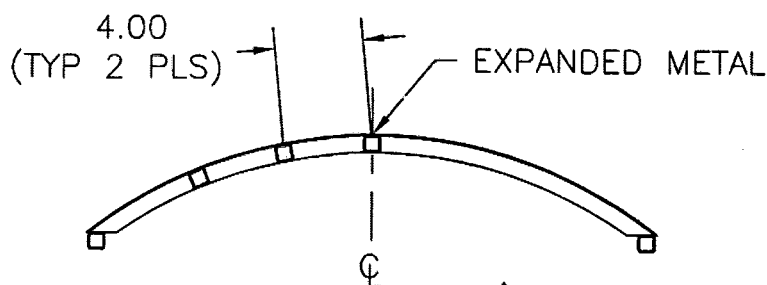
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CHECKED #	APPROVED #	DRAWING NO. D2512	REV. D SHEET 4 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE 1:8



SECTION C-C SIMILIAR BOTH END RIBS



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

06.06.24
UNDER REVIEW

08.02.05
TUBING TO BE
CHANGED TO 0.085
WALL

RELEASED
01.04.27

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